

Date: Thursday, 2/9/2006 1:17:17 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACK FRAME ASSEMBLY
Job Number : 25792	
Estimate Number : 11129	
P.O. Number : N/A	Part Number : D3017041
This Issue : 2/9/2006 S.O. No. : N/A	Drawing Number : D3017 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 25791	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 3/15/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.02.09</u>	
Comment : Est. A 01.09.19 New issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)  
 4130 Tube .750 OD x.049W  
 Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall  
 Batch: M11642

06/07/25 ①

2.0	M4130NS049	4130 Sheet .049 wall
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Comment: Qty.: 0.1260 sf(s)/Unit Total : 0.1260 sf(s)  
 4130 Sheet .049 wall  
 Cut:- AISI 4130N sheet, 18 gauge (0.050 thick)  
 Batch: M16443

06/07/25 ①

3.0	D30177	Lug
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Lug  
 Pick:  
 Qty Part Number Description Batch  
 3 D3017-7 Lug 22411

06/07/25 ①

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1  
 1-Cut all tubes as per Dwg D3017  
  
 2-Cut end caps as per Dwg D3017  
  
 3-Weld as per Dwg D3017 using Welding Jig Dt8598  
 A/R Steel Rod Batch: M9430

06/07/25 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DE Date: 02/08/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 25792

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill D3017-041 Using DT8621

5-Deburr

5.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-07-28

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SC 06/07/31  
DL

①

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/08/08 ①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA

SB 06/08/08 ①

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

PA 06/08/15

Job Completion



C Loc 08/15

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

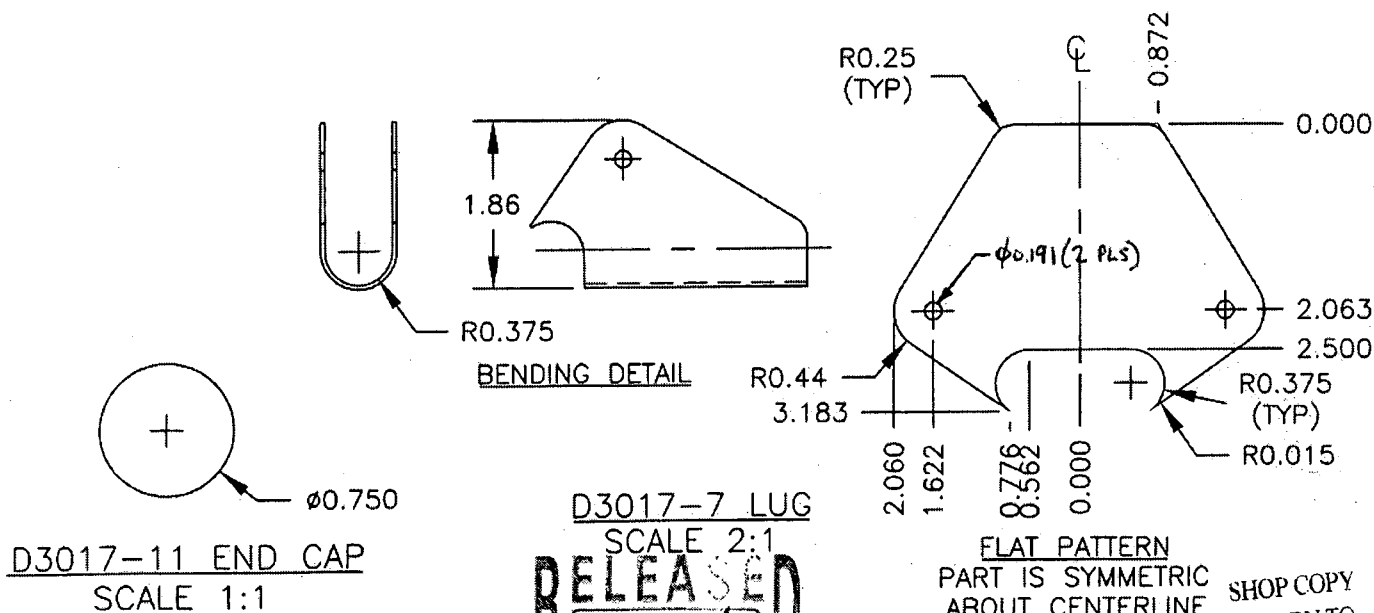


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

#### NOTES

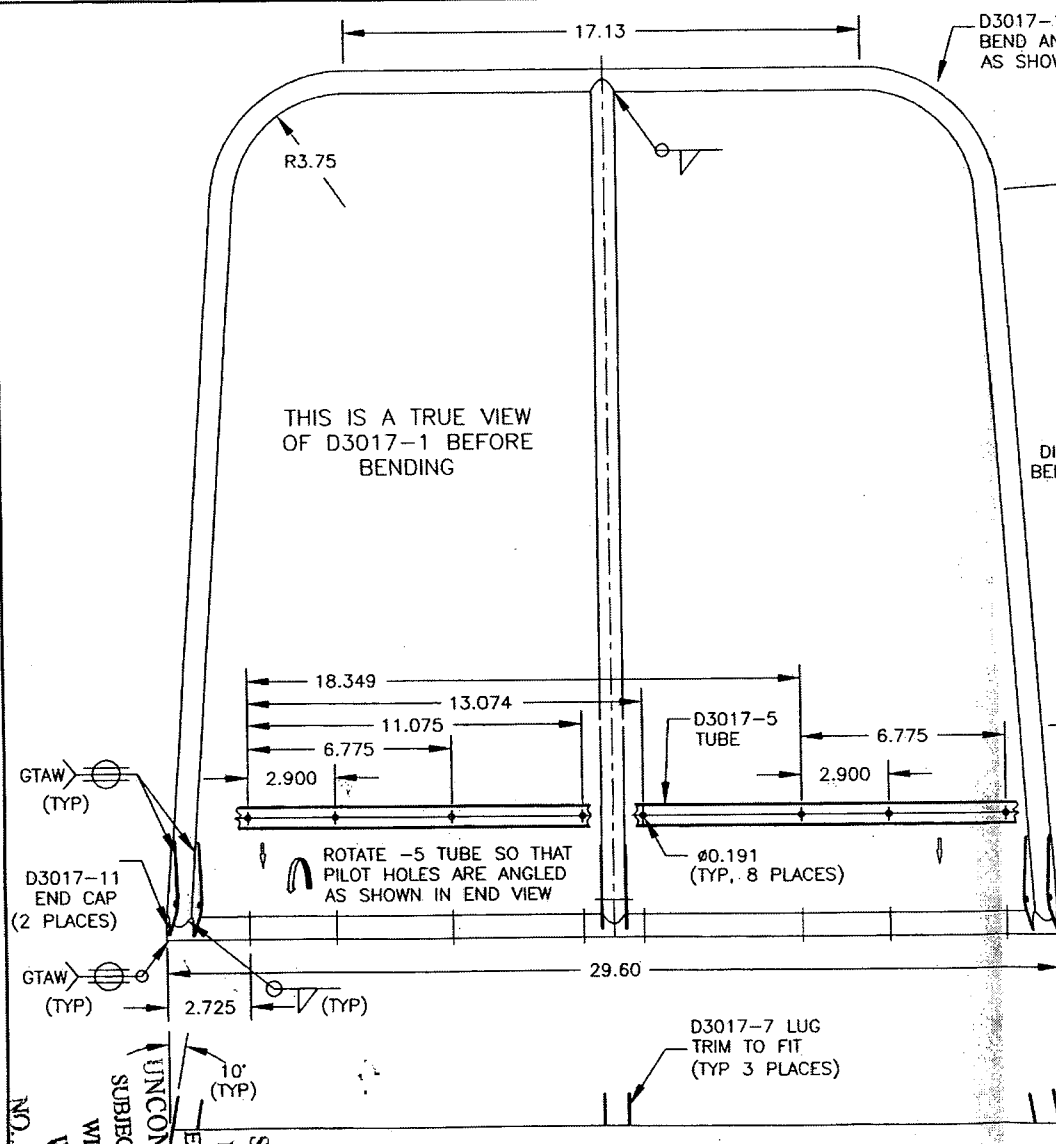
- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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WITHOUT NOTICE  
WORK ORDER  
NO. 25792

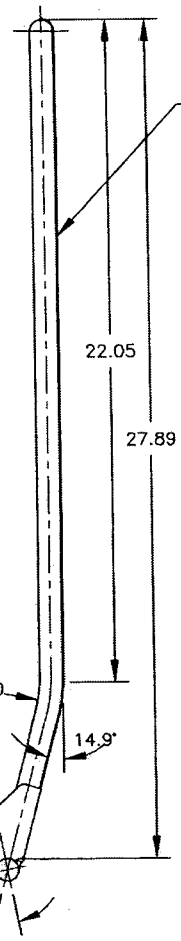


D3017-1 TUBE, BEND AND CUT AS SHOWN

17.92  
DIST BETWEEN  
BEND TANGENTS

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

26.2°  
ANGLE TO HOLE CENTERLINE



R0.38  
(TYP)

21.30

27.14

D3017-3 TUBE

D3017-041 BACK FRAME ASSEMBLY  
(D3017-1 TUBE, D3017-5 TUBE)

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DESIGN	AP	DRAWN BY	AP	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	AP	APPROVED	AP	DRAWING NO. D3017	REV. A
DATE	01.05.18	TITLE	BACK FRAME ASSEMBLY	SHEET 2 OF 2	SCALE 1:4

NO. 25792

WORK ORDER

SUBJECT TO AMENDMENT WITHOUT NOTICE

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ENGINEERING

RETURN TO

SHORE

USED

74 M11647